

Date: Friday, 7/21/2006 7:37:31 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LATCH ASSEMBLY
 Job Number : 28020
 Estimate Number : 10303
 P.O. Number : *N/A* Part Number : D2586
 This Issue : 7/21/2006 S.O. No. : *N/A* Drawing Number : D2586 REV C1
 Prsht Rev. : NC Project Number : N/A
 First Issue : *N/A* Type : PURCHASED PARTS Drawing Revision : C1
 Previous Run : 26079 Material : *N/A*
 Written By : *SELF COMMENT BELOW* Dwg Date : 8/5/2006 Qty: 100 Um: Each
 Checked & Approved By : *06.07.21*
 Comment : Est E 02.01.31 Added Inspect level 21 NG

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: *1739*Possible Supplier: Southco, P/N: C2-32-25 *u* *06.07.21*

Certification Required

2.0 C23225 DOOR LATCH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)
 DOOR LATCH

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

1-Receive and inspect for transit damage

2-Attach certification *LB 06.07.31 L.O.*

3-Stock Keys as: C2-32-25 Keys

4-Discard hardware

4.0 D30157 Lock Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)
 Lock Nut

Pick:

Qty Part Number Description Batch

1 D3015-7 Lock Nut *B26324**FF 06.08.11*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
060802	3.1	QCS before production. Added to estimate. perm. change						
		QCS by:						

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/08/17

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH ASSEMBLY

Job Number: 28020

Part Number: D2586

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill Hole to 0.191"

2-Counterface as per Dwg D2586

3-Assemble Lock Nut to Hinge. Leave Latch Unlocked.

FF 06.08.10 100

FF 06.08.11 100

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 04/08/14 100

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 190

~~LB 06/08/02~~ RB 06/08/16

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SB 06/08/17

Job Completion



C 06/08/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

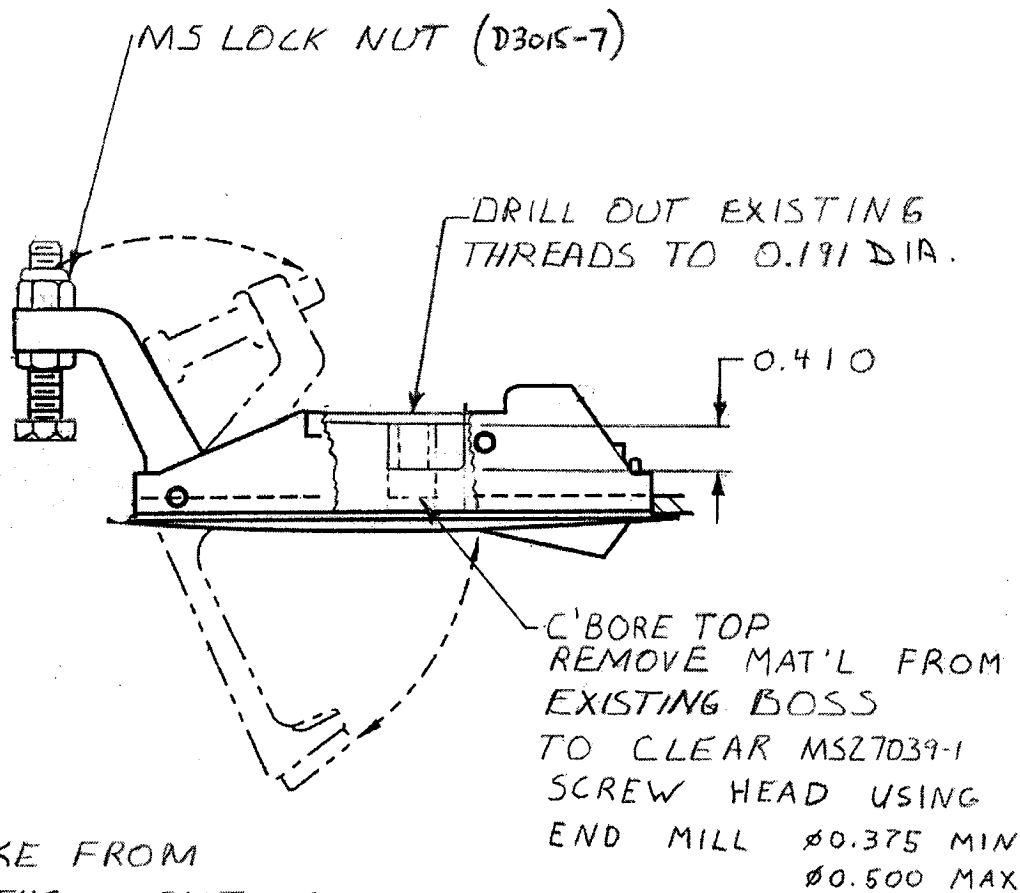
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2586	REV C SHEET 1 OF 1
DATE 97.09.03	TITLE DOOR LATCH		SCALE NTS
A	96.07.15	NEW ISSUE	
B	97.07.23	CHANGED C'BORE DEPTH	
C	97.09.03	REVISED C'BORE DEPTH	
CI	#CP 01.06.27	ADD 3015-7 P/N	

RELEASED
97/09/04 KE
TSR A364

NOTE: MAKE FROM
SOUTHCO PART# C2-32-25

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28020

T.C.H. Sales Inc.
40 Emblem Court
Toronto, Ontario M1S 1B1

Trans Continental Hardware
1370 William St. Suite 4
Buffalo, New York 14206

Trans Continental Hardware
10552 King William Drive
Dallas, TX 75220

1-800-465-6281
www.tchweb.com



CERTIFICATE OF COMPLIANCE

Date: July 28/06

Customer Name Dart Aerospace

Customer P.O. No.: 1739

TCH Order No.: 67365

Invoice No.: 82301

Date shipped: July 28

TCH Part No.: SSS-C23225

Item Description: BLK Lev Latch Raised Trigger w/LK

This is to certify that the items identified herein have been produced in accordance with applicable instructions and or specifications, drawings, approved samples and/or other descriptions set forth in the Purchase Order.

Signature: _____

Title: _____

Supervisor